

17-4 H900 5/8

Work Order ID 140001

140001

Page 1

December 16, 2015 11:57:34 AM

Item ID: E4715-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Stud

Start Date: 12/16/2015 Start Qty: 36.00

36

Cust Item ID:

Required Date: 3/1/2016 Req'd Qty: 36.00

36

Customer:

Reference:

Approvals:

Process Plan:

SK

Date: 0151217

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

E4715

REV PA2

A M

100

0.00

100

DOOSAN LATHE

Doosan

Memo

0.09

Doosan Lathe

1- Turn as per Folio

Rev: AA & Dwg D

Rev: A

3-Deburr per dwg

37

φ

DAS

45

9-89

2016-3-7

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.01

Quality Control

37

φ

DA:

45

9-89

2016-3-7

Work Order ID 140001

December 16, 2015 11:57:34 AM

140001

Page 2

Item ID: E4715-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Stud
Start Date: 12/16/2015 Start Qty: 36.00 ***36*** Cust Item ID:
Required Date: 3/1/2016 Req'd Qty: 36.00 ***36*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC8- Inspect parts - second check	0.00							DAS 08 9-89
140									

QC
Quality Control
Memo
100% CHECK,CHECK ALL DIMENSIONS AND THREAD FIT

B. 16/03/08

37

0

150		0.00							
150	PURCHASING								
Purchasing	Memo	0.00							
Purchasing	Issue P/O: 31650								
	LPI Per ASTM 1417 LEVEL 2								
	Certificate of conformaty is required								

37

MAR 15 2016

DAS
13
9-89

160	Receive & Inspect for Damage & Mat'l Certs	0.00							
160									
Packaging	Memo	0.01							
Packaging	Ensure certificate of conformity is attached								

37x 50/6-03-15.

Work Order ID 140001

140001

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December 16, 2015 11:57:34 AM

Item ID: E4715-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Stud

Start Date: 12/16/2015 Start Qty: 36.00

36

Cust Item ID:

Required Date: 3/1/2016 Req'd Qty: 36.00

36

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.01

Quality Control

37

DAS
38
9-89

MAR 15 2016

180

Identify as per dwg & Stock Location: St 167

0.00

180

Packaging

Memo

0.01

Packaging

37

DAS
9-89

MAR 15 2016

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.06

Quality Control

MLJ

MAR 21 2016

MLJ

MAR 21 2016

Picklist Print

December 16, 2015 11:57:39 AM

Page 1

Work Order ID: 140001

140001

Parent Item: E4715-1

F4715-1

Parent Item Name: Stud

Start Date: 12/16/2015

Required Date: 3/1/2016

Start Qty: 36.00

Required Qty: 36.00

Comments: IPP REV:A NEW ISSUE 12-10-15 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174PH-H900R0.625		Purchased			No		f	32.4000		10.8			

M174PH-H900R0 625

17-4 SS H900 ROUND BAR 0.625

Location

Loc Qty

Loc Code

MAT031

32.4

M129892

32.4

10.05^{ft} DAS
45 2016-3-7
9-89

DART AEROSPACE LTD		Work Order:	140001
Description: stud		Part Number:	E4715-1
Inspection Dwg: E4715 Rev: A		Page 1 of 1	

INSPECTION SHEET

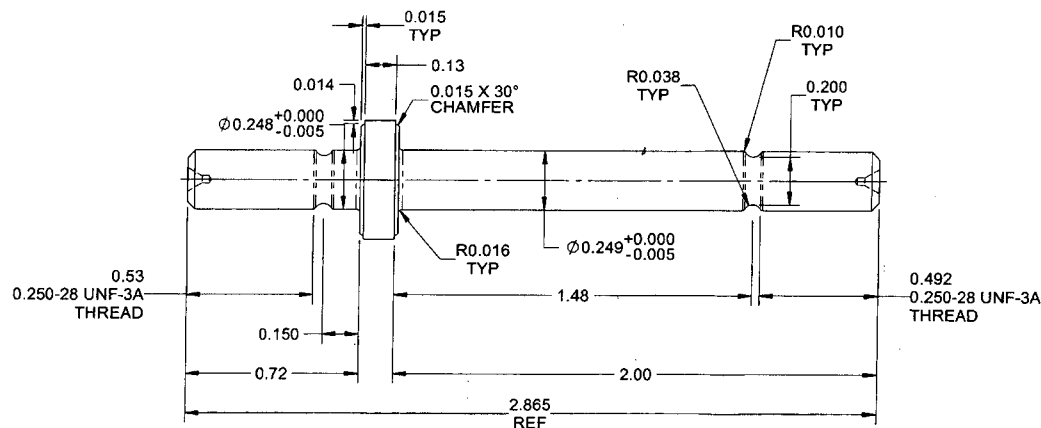
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1/4-28 UNF 3A	N/A	OK	✓		NUT	Shop
φ min - φ max	0.2435 - 0.250	0.245	✓		mic 0-1	JTC-02
P min - P max	N/A	✓				
MOW .024	0.2653 - 0.2678	0.2663	✓		mic 0-1 + Pin	JTC-02 + Shop
0.53	+/- 0.03	0.53	✓		caliper	JTC-01
0.248	+0.0001 - 0.0005	0.2475	✓		mic 0-1	JTC-02
0.014	+/- 0.010	0.014	✓		caliper	JTC-01
0.150	+/- 0.010	0.150	✓		"	"
0.72	+/- 0.03	0.723	✓		"	"
0.015	+/- 0.010	0.015	✓		"	"
0.13	+/- 0.03	0.13	✓		"	"
0.015 x 30°	+/- 0.010	0.015 x 30°	✓		" + Ang b	" + Shop
R 0.016	+/- 0.010	R 0.015	✓		rad b	Shop
0.249	+0.0001 - 0.0005	0.245	✓		caliper	JTC-01
1.48	+/- 0.03	1.48	✓		"	"
2.00	+/- 0.03	2.00	✓		"	"
2.865	REF (N/A)	2.868	✓		"	"
R.038	+/- 0.010	R.032	✓		rad b	Shop
R.010	+/- 0.010	R.010	✓		"	"
0.200	+/- 0.010	0.201	✓		caliper	JTC-01
1/4-28 UNF 3A	N/A	OK	✓		NUT	Shop
φ min - φ max	0.2435 - 0.250	0.2465	✓		mic 0-1	JTC-02
P min - P max	N/A	✓				
MOW .024	0.2653 - 0.2678	0.267	✓		mic 0-1 + Pin	" + Shop
0.492	+/- 0.010	0.492	✓		caliper	JTC-01
0.010	+/- 0.010	0.010	✓		"	"
0.470	+/- 0.010	0.470	✓		"	"
0.498	+0.0001 - 0.0005	0.4954	✓		mic 0-1	JTC-02

DAS
45

Measured by: 9-89	Checked by: B.A.	DAS 08 9-89	QC Inspector:
Date: 2016-3-7	Date: 16/03/08		Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	



E4715-1 STUD

NOTES:

- 1) MATERIAL: 17-4 PH/S17400/TYP 630 STAINLESS STEEL ROUND BAR, H900 CONDITION PER AMS5643, OR ASTM A564 REF DART SPEC M17-4R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: 0.046 lbs
- 8) CENTER DRILL MAY BE #1 OR #2
- 9) PENETRANT INSPECT PER QSI 038 4.1

20151217

3A 140001

A		NEW ISSUE		RF	12.08.29	
REV.		DESCRIPTION			BY	DATE
DESIGN	RF	EAGLE COPTERS LTD. CALGARY, ALBERTA, CANADA				
DRAWN	RF					
CHECKED	RF	DRAWING NO.	REV. A			
MFG. APPR.	RF	E4715	SHEET 1 OF 2			
APPROVED	RF	TITLE	SCALE			
DE APPR.	RF	STUD	NTS			
DATE	12.08.29	COPYRIGHT © 2012 BY EAGLE COPTERS LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM EAGLE COPTERS LTD.				



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO31650**

Purchase Order Date 3/10/2016

PO Print Date 3/15/2016

Page Number 4 of 5

Order From :

SKYSERVICE
6120 MIDFIELD ROAD
MISSISSAUGA, ONTARIO L5P 1B1
CANADA

VC-SKY001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 905-678-5636

Ship To Contact

Ship To Phone

Ship Via: Delivered

Ship Acct:

Buyer

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB FCA - (Free Carrier)

Line Total: \$0.00

9	138760	D350-748-203 CROSSTUBE	3/11/2016	1.00	\$0.00	\$0.00
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Yes
3/11/2016

LIQUID PENETRANT INSPECTION AS PER QSI 038 OR
LPI AS PER ASTM 1417 LEVEL 2

Line Total: \$0.00

10	141832	D350-748-203 CROSSTUBE	3/11/2016	1.00	\$0.00	\$0.00
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Yes
3/11/2016

LIQUID PENETRANT INSPECTION AS PER QSI 038 OR
LPI AS PER ASTM 1417 LEVEL 2

Line Total: \$0.00

11	140001	E4715-1 STUD ✓	3/11/2016	37.00	\$0.00	\$0.00
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Yes
3/11/2016

LIQUID PENETRANT INSPECTION AS PER QSI 038 OR
LPI AS PER ASTM 1417 LEVEL 2

Note:

3/15/2016

SP/6-03-15

skyservice Work Order Traveler

Sky Service F.B.O. Inc.

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO27600	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: 31650
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT ON FORTY - EIGHT STUDS AS PER PO : 31650

ELEVEN STUDS , ITEM ID : E4715-3 . W/O ID : 140000

THIRTY - SEVEN STUDS , ITEM ID : E4715-1 , W/O : 140001

SP16-23-15

Action Taken:	Date:	Initial/Stamp:
LIQUID PENETRANT INSPECTION CARRIED OUT AS PER ASTM E-1417M-13 NO CRACK FOUND PEN.(ZL-37 , B#MPO13139), DEV.(SKD-S2,B#MPO11715) , EMU.(ZR-10B,B#MPO12373 DAS 38 9-80 MAR 15 2016	MAR 11 2016	<i>Lu</i> DOT-APP 37 53-89

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp	Date:
Name: LUCA MARCHETTA	DOT-APP 37 53-89	MAR 11 2016